

Work Order ID 149493

Monday, July 25, 2016 10:53:08 AM

149493

Page 1

Item ID: D2666-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, RH, Fwd, Aft, In

Start Date: 7/25/2016 Start Qty: 2.00 *2*

Required Date: 7/29/2016 Req'd Qty: 2.00 *2*

Cust Item ID:

Reference: touch up, return to stock *REWORK*

Customer:

Approvals: Process Plan: *[Signature]* Date:

Tooling: Date:

Run Start *NR1*

QC: *[Signature]* Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D2666

Rev D

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

150

Powdercoat

Powder Coating

Memo

PULL FROM TRIAL FIT:
1 X D2666-2 B121591
1 X D2666-2 B113167

TOUCH UP A/R

M135418

*START: 10:05.
O.U.T: 2000
FINISH 10:35.*

(X2) ✓

M.8 16.08.1

2 1611-25 333

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

2

DAS
38
9-88
NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Work Order NCR

Reviewed
DQA:
Date:

Printed on: Thursday, August 18, 2016

Details

Raised Date 8/18/2016	Status Open	Owner Maranda, Denis	Number NCR16-5986
Target Date 9/5/2016	Standard	Severity	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Engineering	Fault Category General\Finish	

Details

Saddles were use for trial fit by engineering. After trial fit completed saddles had little damage cause by the hardware getting in contact with the saddle and removing the powder coat and in some places the alodine was remove too. In order to fix this issue engineering decided to use white tough paint which turn out to be not acceptable by QC because of the variance in the colour. Parts and work order affected D2666-2 B149493, D2662-1 B149491, D2661-2 B149489, D2661-1 B149490, D2665-2 B149496, D2662-2 B149492, D2665-1 B149495. Picture attach

Keywords	Product D206-642\D2666-1	
Document	Root Cause	
Closed By	Closed Date	Resolution

Corrective Action

Target Date 9/5/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details			
1	Smith, Patrick	9/2/2016	
get approval to re powder coat saddles			
2	Sheldon, Andrew	9/2/2016	
after approval from DQA, strip saddles			
3	Roquebrune, Benoit	9/2/2016	
touch up alodine as required and powder coat as per QSI005			
4.3			

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Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, RH, Fwd, Aft, In

Start Date: 7/25/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/29/2016 Req'd Qty: 2.00

2

Customer:

Reference: touch up, return to stock

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

Identify as per dwg & Stock Location **ST 402** 0.00***170***

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

2X

NOV 25 2016

**DAS
26
9-89**

180

QC21- Final Inspection - Work Order Release

0.02

180

QC

Memo

0.03

Quality Control

16/11/28 **JA****DAS
21
9-89**

NOV 25 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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240 35 38-0																																																																	
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 25, 2016 10:53:08 AM

Work Order ID: 149493

149493

Parent Item: D2666-2

D2666-2

Parent Item Name: Saddle, RH, Fwd, Aft, In

Start Date: 7/25/2016

Required Date: 7/29/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2666-2		Manufactured	No				Each	4.0000		2			
D2666-2									**			16-08-15	
Saddle, RH, Fwd, Aft, In													

Location

ST402

145890

Loc Qty

4

4

Loc Code

1 X B121591

1 X B113167

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

Linda Lacelle

From: Steven Drouin
Sent: Thursday, July 21, 2016 2:23 PM
To: Linda Lacelle
Subject: w/o for touch up paint

Hi Linda

I will need a w/o for paint touch up on these parts

D2661-2 x 2 B129615, B121702 — 149489
D2661-1 x 2 B141282 — 149490
D2662-1 x 2 B124309 — 149491
D2662-2 x 2 B129616 — 149492

D2666-2 x 2 B121591 B113167 — 149493
D2666-1 x 1 B109550 — 149494
D2665-1 x 1 B120551 — 149495
D2665-2 x 2 B136230 — 149496

And Aft Crosstube
D206-667-201 B140408 — 149497

Steven Drouin

Dart Aerospace

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Special Projects Coordinator
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Tel: 613-632-5200 ext. 240
Fax: 613-632-9311

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					